

Aero Design Ltd.**Work Order Control Sheet**Work Order#: **2017-174** Date Opened: **26 October 2017** Title: **Assembly**Aircraft OEM: **Bell** Aircraft Model: **429** Product Type: **Cargo Basket** Product Model: **RH Post S/N 81** Quantity: **1****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

CB/JC
N/A
CB/JC
CB/JC
JC
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

CB/JC
CB/JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
95950	0	Basket Assembly	JC
95917	1	Lid Checker Plate	JC
95965	0	Fwd Sheet	JC
95916	1	Filler Sheet	JC
95927	1	Placard	JC
84240	0	Lid Brace Installation	JC
84255	2	Handle Installation	JC
36261	2	Handle Assembly	JC

Traveller

Install checker plate on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

JR
CB/JR
CB/JR
CB/JR
CB/JR
JR
CB/JR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Work performed by:

Print: C. Brander/J. RekveSign: SCA: AD01Date: 26-Oct-17

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: SCA: AD02Date: 26-Oct-17

Work Order closed by:

Print: J. ClarkeSign: SCA: AD02Date: 10-Nov-17

Approved Manufacturing Facility 73-04

Form 20.D.03

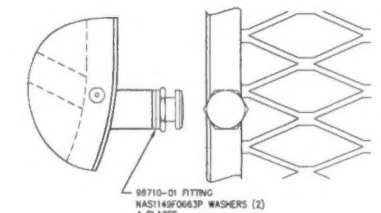
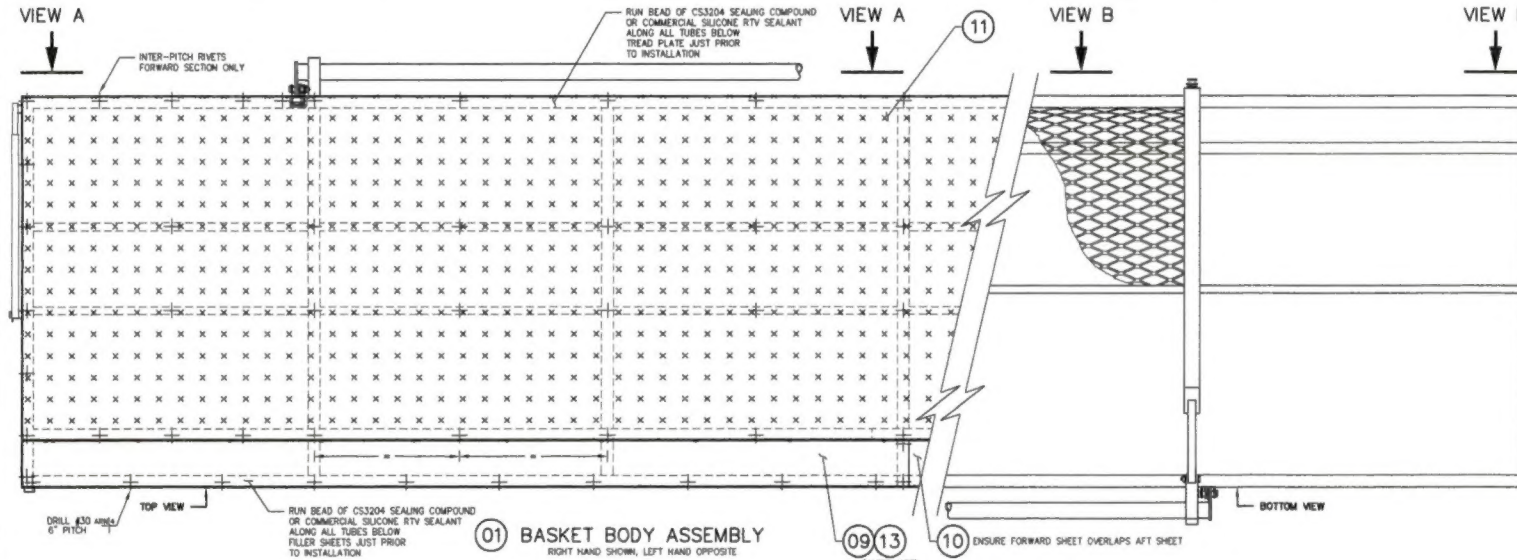
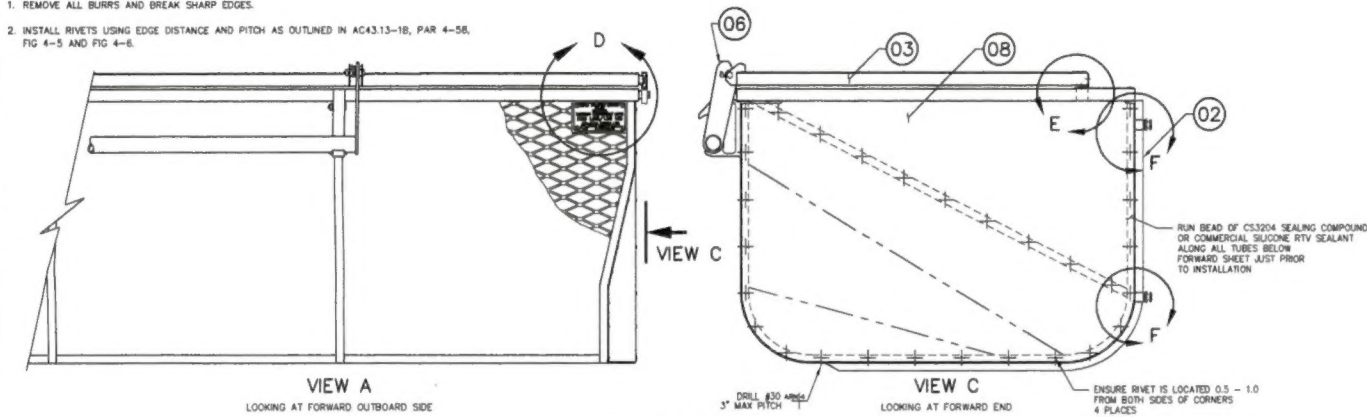
Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0399
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-174
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	95950-01-01	1	95911-07	New
12. Remarks Grey					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature 14c. Approved Organization Number	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 26 Oct 2017		14d. Name 14e. Date (dd/mmm/yyyy)	
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

MV CLOUDBREAK

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. INSTALL RIVETS USING EDGE DISTANCE AND PITCH AS OUTLINED IN AC43.13-1B, PAR 4-56, FIG 4-5 AND FIG 4-6.



DETAIL F

SCALE 1 : 1
LOOKING AT FORWARD LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR
REAR ATTACHMENTS SIMILAR

A/R/A/R	---	SILICONE SEALANT (CLEAR)	COMMERCIAL
A/R/A/R	CS3204	SEALING COMPOUND	AMS-5-BB02C T2 B1/2
B/B	NAS1148F0663P	WASHER	ALT: ANCR4 4006B-14
4/4	08710-01	FITTING	ALT: HR3213-4-02
A/R/A/R	CR3213-4-02	CHERRY RIVET	ALT: HR3223-5-02
B/B	CR3223-5-02	CHERRY RIVET	ALT: HR3213-5-02
A/R/A/R	CR3213-5-02	CHERRY RIVET	ALTERNATE TO 09/10
A/R/A/R	95918-03	13 FILLER SHEET	ARGUS INDUSTRIES
4/4	48203-14	12 BUMPER	
1/1	95917-02	11 LH LID CHECKER PLATE	
1/1	95917-01	11 RH LID CHECKER PLATE	
1/1	95918-02	10 AFT FILLER SHEET	
1/1	95918-01	09 FORWARD FILLER SHEET	
1/1	95965-02	08 LH FORWARD SHEET	
1/1	95965-01	08 RH FORWARD SHEET	
1/1	95927-04	07 LH PLACARD	
1/1	95927-03	07 RH PLACARD	
1/1	84255-01	06 HANDLE BAR INSTALLATION	
1/1	MS20001P4	05 PIANO HINGE	95" LONG
1/1	84240-01	04 LID BRACE INSTALLATION	
1/1	95912-01-02	03 LH LID ASSEMBLY	
1/1	95912-01-01	03 RH LID ASSEMBLY	
1/1	95951-01-02	02 LH BASKET BODY ASSEMBLY	
1/1	95951-01-01	02 RH BASKET BODY ASSEMBLY	
1/1	95950-01-02	01 LH CARGO BASKET ASSEMBLY	
1/1	95950-01-01	01 RH CARGO BASKET ASSEMBLY	
-02/-01	PART NO.	ITEM	MATERIAL
QTY	QTY	QTY	QTY

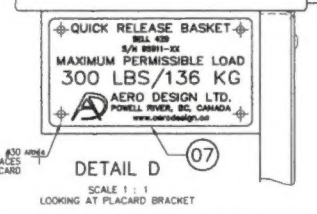
LIST OF MATERIALS

AERO DESIGN LTD.
8888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.483.3276 www.aerodesign.ca

BELL 429 - S/N 57081 & SUB.
QUICK RELEASE CARGO BASKET
CARGO BASKET ASSEMBLY

SCALE 1 : 4
SHEET 1 OF 1
A1 95950 0

BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF. NAS 523	R=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE	DRAWN: JEFF CLARKE	20 FEB 2014
C-COUNTERSUNK	DASH NO. FOR LENGTH	CHECKED:	
D=IMPLE		JASON REKVE	
DIGIT=# OF SHEETS TO BE DIMPLED			
BASIC CODES:			
BU=MS20470AD	+ INSTALL NEW RIVET		
BB=MS20426AD	+ REMOVE/REPLACE RIVET		
ARN=CR3213	- EXISTING RIVET		
ATN=CR3523			



BUMPER INSTALLATION

SCALE 1 : 1

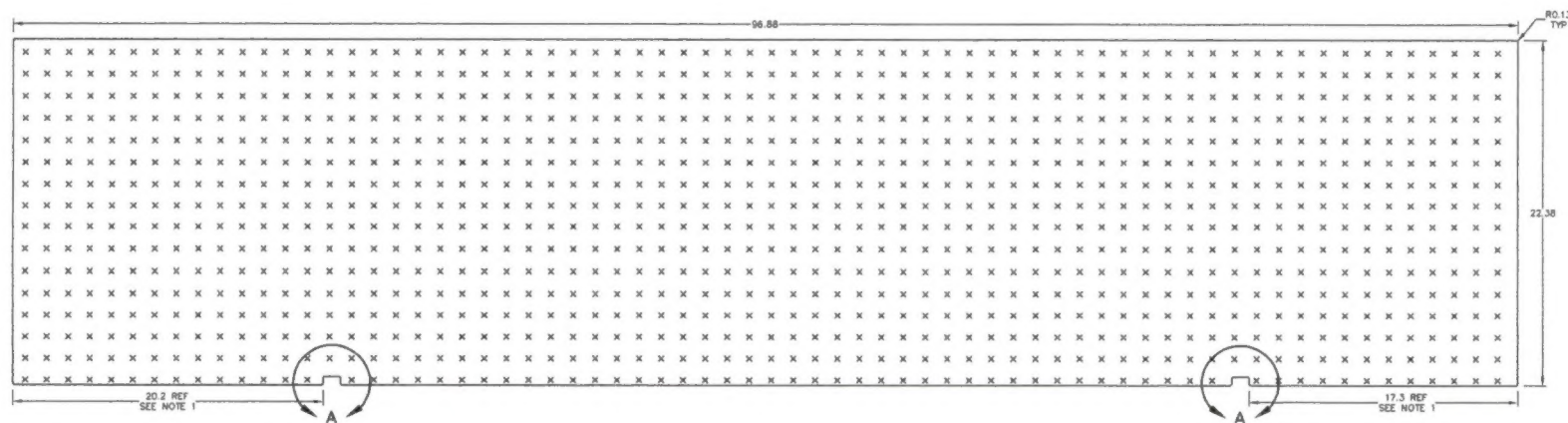
DETAIL E

SCALE 1 : 1
LOOKING AT HINGE

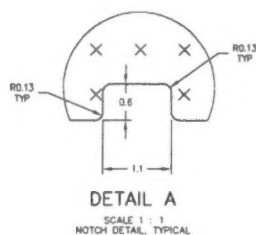
DETAIL D

SCALE 1 : 1
LOOKING AT PLACARD BRACKET

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THE DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR ABUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK	BJC	10/04/2014




01 LID CHECKER PLATE
RIGHT HAND SHOWN, LEFT HAND OPPOSITE

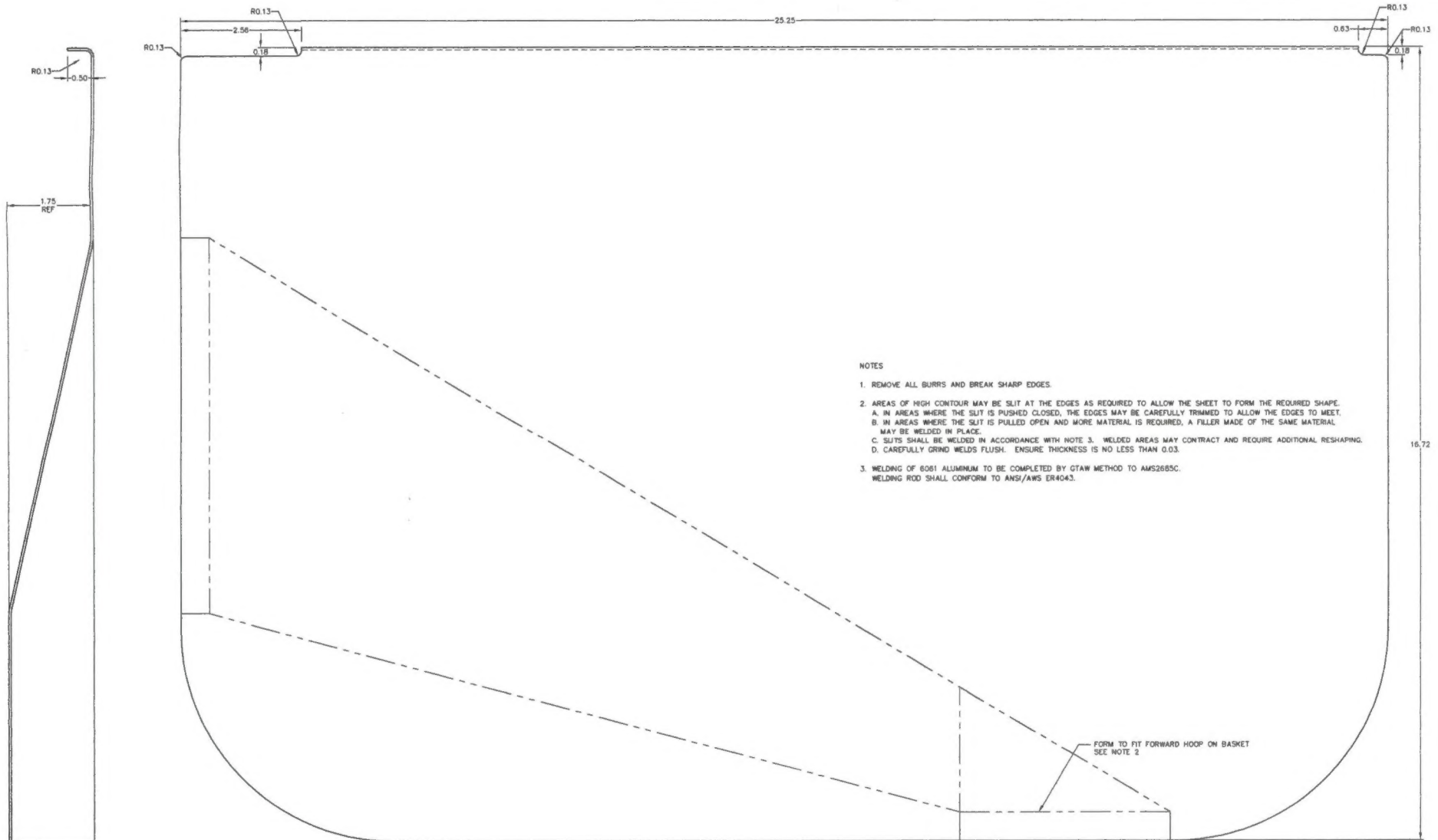


NOTES

1. LOCATION OF NOTCHES TO FIT LID ASSEMBLY 95912-01.
2. REMOVE ALL BURRS AND BREAK SHARP EDGES.

1	95917-02	01	LH LID CHECKER PLATE	3003 ALUMINUM	COMMERCIAL	0.063" C-102 CHECKER						
1	95917-01	01	RH LID CHECKER PLATE	3003 ALUMINUM	COMMERCIAL	0.063" C-102 CHECKER						
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE						
LIST OF MATERIALS												
<table><tr><td>APPROVALS</td><td>DATE</td></tr><tr><td>DRAWN: JEFF CLARKE</td><td>09 NOV 2012</td></tr><tr><td>CHECKED: E. BURCOIN</td><td>10 NOV 2012</td></tr></table>				APPROVALS	DATE	DRAWN: JEFF CLARKE	09 NOV 2012	CHECKED: E. BURCOIN	10 NOV 2012	<div>AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.3376 www.aerodesign.ca</div>		
APPROVALS	DATE											
DRAWN: JEFF CLARKE	09 NOV 2012											
CHECKED: E. BURCOIN	10 NOV 2012											
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:				BELL 429 QUICK RELEASE CARGO BASKET LID CHECKER PLATE FABRICATION								
DECIMALS		ANGLES		SCALE 1 : 4								
X.XXX ±0.010		±1/2°		DWG. NO. REV.								
X.XX ±0.03				A1 95917 1								
X.X ±0.1				SHEET 1 OF 1								

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		

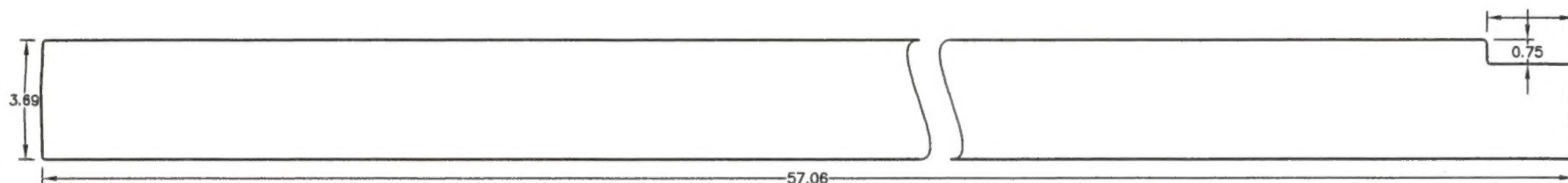


01 FORWARD SHEET
RH SHOWN, LH OPPOSITE

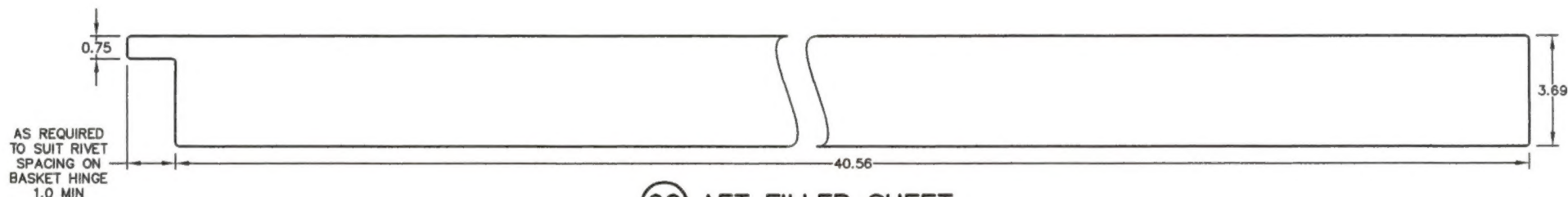
		95965-02	01 FORWARD SHEET (LEFT HAND)	6061 ALUMINUM	QQ-A-250/11	0.050 SHEET	
		95965-01	01 FORWARD SHEET (RIGHT HAND)	6061 ALUMINUM	QQ-A-250/11	0.050 SHEET	
-02	-01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	QTY	LIST OF MATERIALS					

APPROVALS		DATE			AERO DESIGN LTD. 6888A MALAPASADA ROAD POWELL RIVER, BC, CANADA V0A 0G3 TEL: 855-462-5376 www.aerodesign-co.ca			
DRAWN: JEFF CLARKE CHECKED: JASON REKVE		10 APR 2014			BELL 429 - S/N 57081 & SUB. QUICK RELEASE CARGO BASKET FORWARD SHEET			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS ANGLES X .XXX ±1/2" X.X ±0.03 X.XX ±0.1								
				SCALE 1 : 1 SHEET 1 OF 1	ORIG. SIZE A1	ORIG. NO. 95965	REV. 0	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; ADD SHEET 2	BJC	10/04/2014



① FORWARD FILLER SHEET




② AFT FILLER SHEET

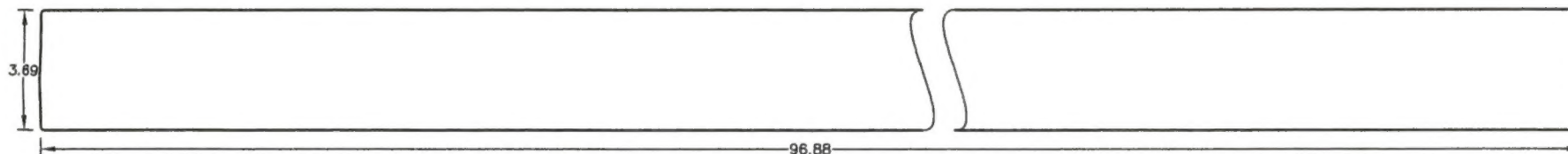
1	95916-02	02	AFT FILLER SHEET	6061-T6 ALUMINUM	QQ-A-250/11	0.050" SHEET
1	95916-01	01	FORWARD FILLER SHEET	6061-T6 ALUMINUM	QQ-A-250/11	0.050" SHEET
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALODINE, EPOXY PRIME AND POLYURETHANE PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.


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	DRAWN:	JEFF CLARKE	09 NOV 2012		9888A MALASPINA ROAD				
	CHECKED:	E. BURGON	10 NOV 2012		POWELL RIVER, BC, CANADA, V8A 0G3				
					TEL: 604.483.2378 www.aerodesign.ca				
NOTICE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			BELL 429					
	DECIMALS			ANGLES		QUICK RELEASE CARGO BASKET			
	X.XXX ±0.010			±1/2°		FILLER SHEET			
	X.XX ±0.03								
	X.X ±0.1			SCALE 1 : 4		DWG. SIZE	DWG. NO.	REV.	
				SHEET 1 OF 2		LGL	95916	1	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; ADD SHEET 2	BJC	10/04/2014



03 FILLER SHEET

1	95916-03	01	FILLER SHEET	6061-T6 ALUMINUM	QQ-A-250/11	0.050" SHEET
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1			
	SCALE 1 : 4 SHEET 2 OF 2			DWG. SIZE LGL
	DWG. NO. 95916			REV. 1

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALODINE, EPOXY PRIME AND POLYURETHANE PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.

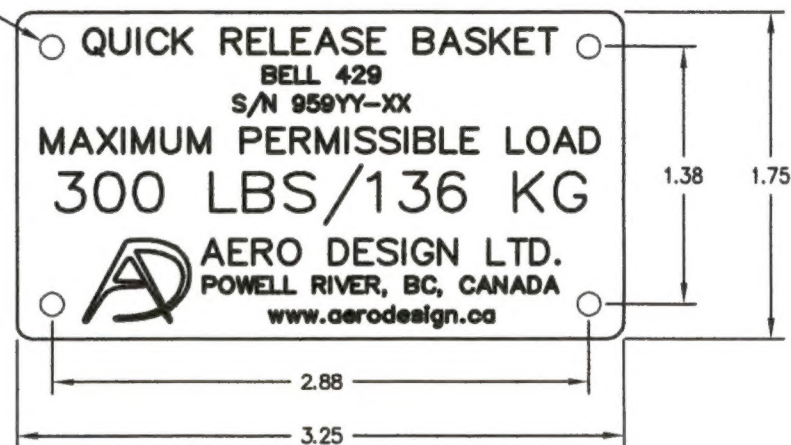
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; ADDRESS, LOGO AND S/N UPDATED	BJC	11/03/2014

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
 "QUICK RELEASE BASKET" - 0.125 HIGH
 "BELL 429" - 0.080 HIGH
 "S/N 959YY-XX" - 0.080 HIGH - (SEE NOTES 2-5)
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
 "300 LBS. TOTAL" - 0.200 HIGH
 "AERO DESIGN LTD." - 0.125 HIGH
 "POWELL RIVER, BC, CANADA" - 0.080 HIGH
 "www.aerodesign.ca" - 0.080 HIGH
- ITEM 01: RH BASKET FOR A/C S/N THRU 57080, S/N TO READ:
 "S/N 95901-XX" - 0.080 HIGH
- ITEM 02: LH BASKET FOR A/C S/N THRU 57080, S/N TO READ:
 "S/N 95902-XX" - 0.080 HIGH
- ITEM 03: RH BASKET FOR A/C S/N 57081 AND SUB, S/N TO READ:
 "S/N 95911-XX" - 0.080 HIGH
- ITEM 04: LH BASKET FOR A/C S/N 57081 AND SUB, S/N TO READ:
 "S/N 95912-XX" - 0.080 HIGH


DRILL #30 (0.129)
4 PLACES



01 02 03 04 PLACARD

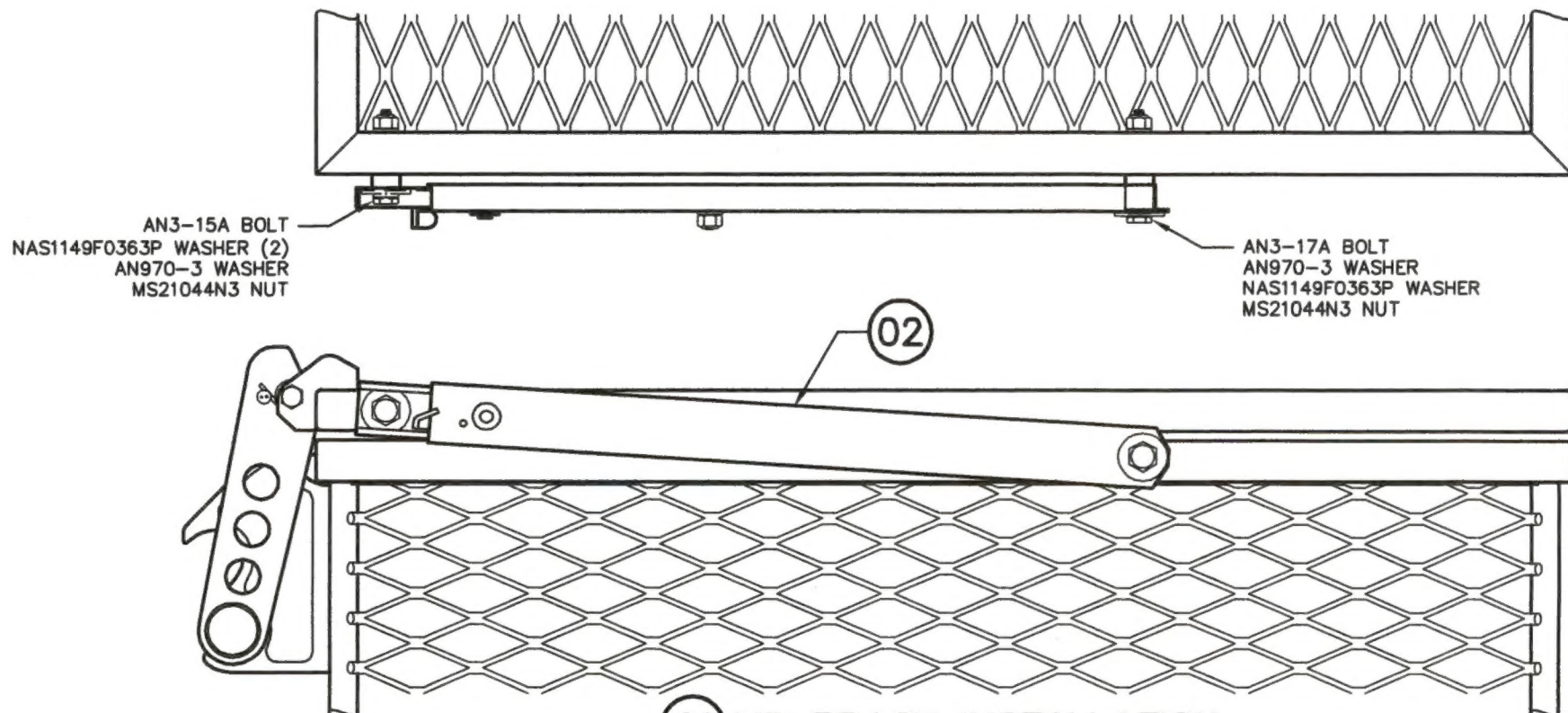
1	95927-04	04	LH PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
1	95927-03	03	RH PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
1	95927-02	02	LH PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
1	95927-01	01	RH PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET

	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

	APPROVALS	DATE		<div>AERO DESIGN LTD.</div> <div>9888A MALASPINA ROAD</div> <div>POWELL RIVER, BC, CANADA, V8A 0G3</div> <div>TEL: 804.483.2376 www.aerodesign.ca</div>			
	DRAWN: JEFF CLARKE	11 SEPT 2012					
	CHECKED: E. BURGOIN	10 NOV 2012					
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: <div>DECIMALS ANGLES</div> <div>X.XXX ±0.010 ±1/2"</div> <div>X.XX ±0.03</div> <div>X.X ±0.1</div>			<div>BELL 429</div> <div>QUICK RELEASE CARGO BASKET</div> <div>PLACARD</div>			
SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.			
SHEET 1 OF 1							
		A1	95927	1			

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



NOTES

1. THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ± 0.010 $\pm 1/2^\circ$
X.XX ± 0.03
X.X ± 0.1



AERO DESIGN LTD.

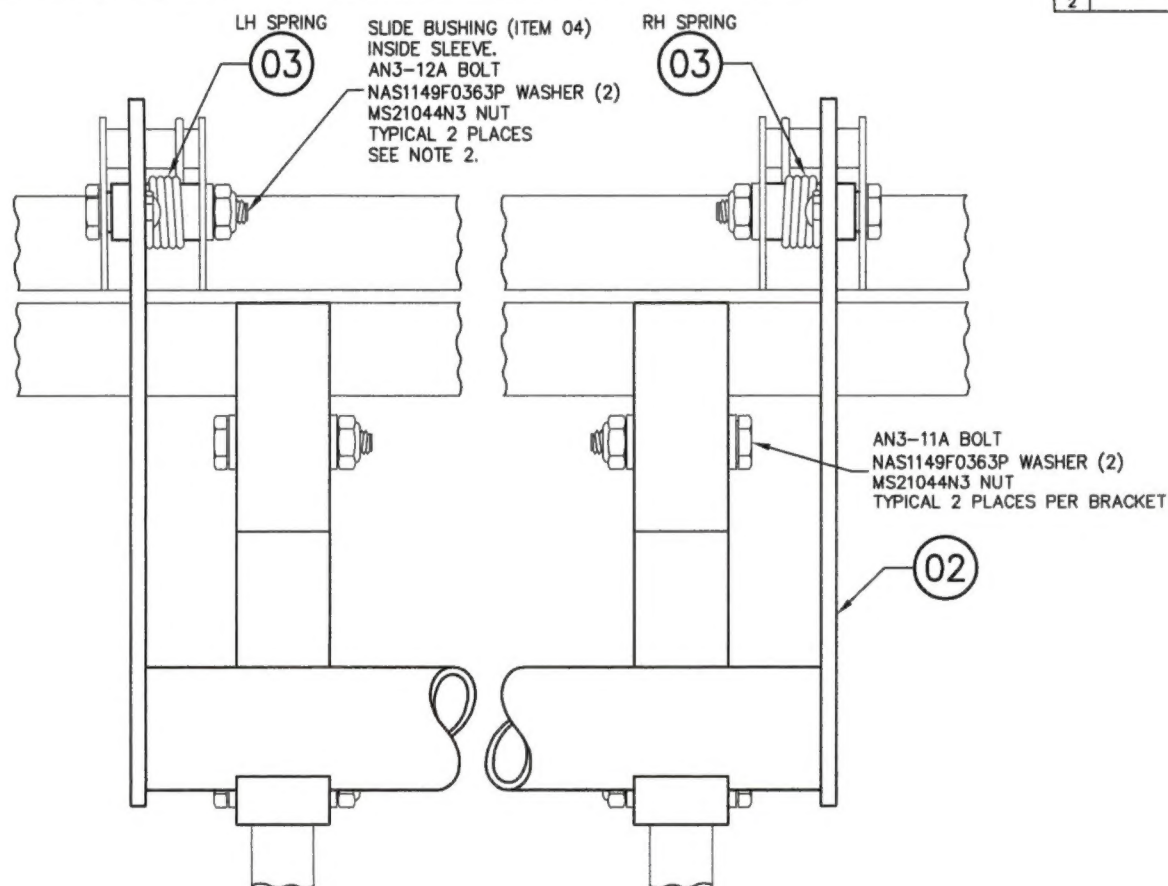
9688A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.2378 www.aerodesign.ca

**HELICOPTER CARGO BASKET
ALL MODELS
LID BRACE INSTALLATION**

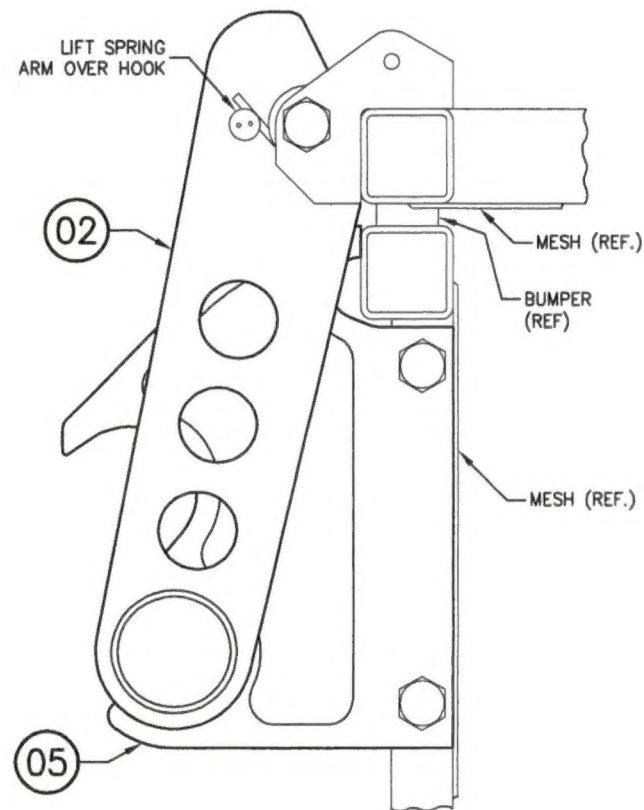
NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



(01) HANDLE INSTALLATION



REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 18/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1	



AERO DESIGN LTD.

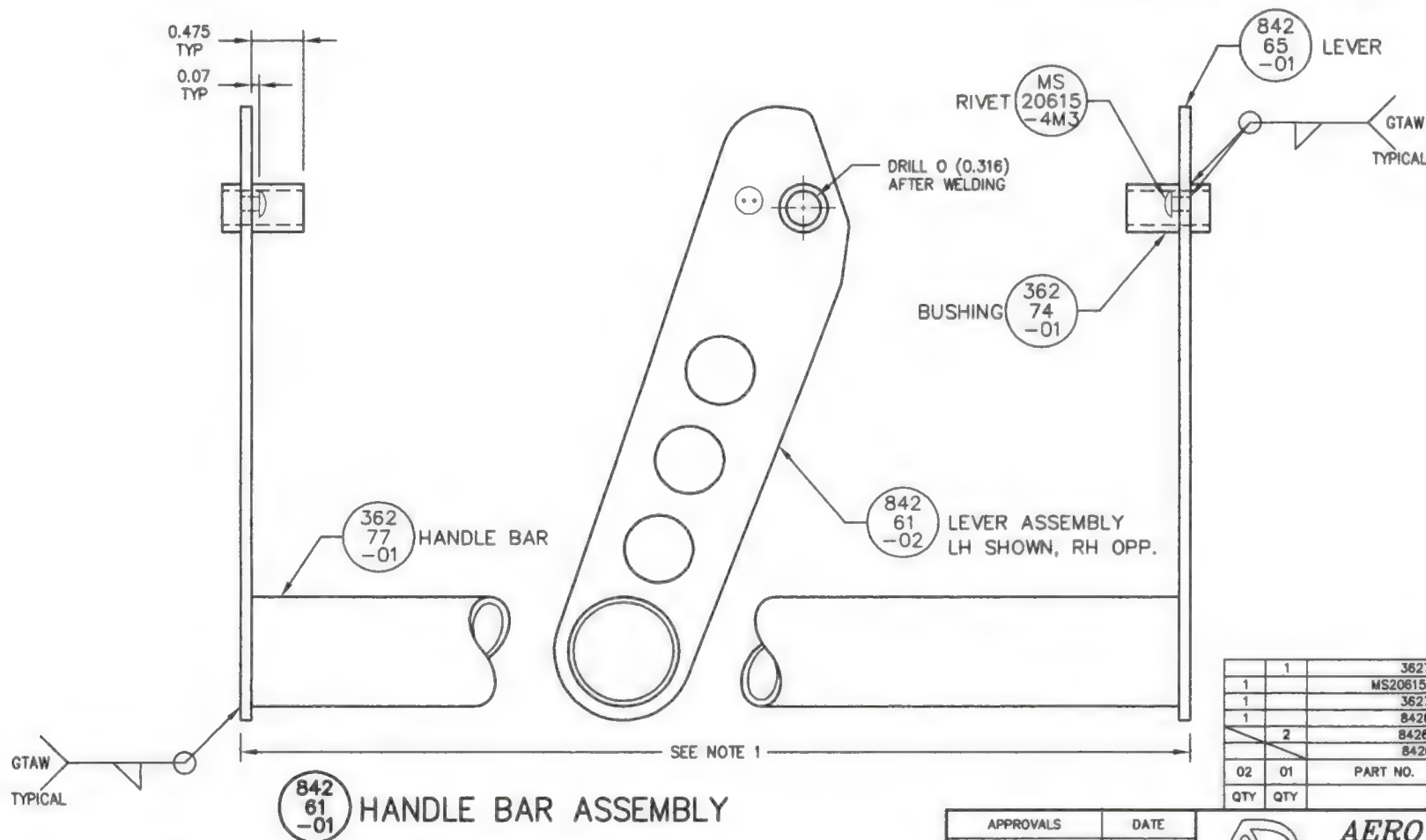
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.463.2276 www.aerodesign.ca

**HELICOPTER CARGO BASKET
HANDLE BAR INSTALLATION**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1	1	36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
2		84261-02	LEVER ASSEMBLY (RH/LH)
		84261-01	HANDLE BAR ASSY
02	01		
QTY	QTY	LIST OF MATERIALS	

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1



AERO DESIGN LTD.

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**HELICOPTER CARGO BASKET
HANDLE BAR ASSEMBLY**

SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 1	A3	84261	2
SHEET 1 OF 1			



WO# 2017-174

Approved Manufacturing Facility 73-04

Rev. Original 27 May 2013



Aero Design Ltd.

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AMF 73-04

In Process

Remarks



Aero Design Ltd.

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Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bell 429 Body R/H No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 95951-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-140

Remaining Tasks to be Performed: Clean up, Inspect, ✓
Powder coat. ✓ GC

Signature: David May

Date: Oct 30/2017 Lic. No. / SCA 7009

In Process



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AMF 73-04

Nomenclature: Bell 429 Lid R/H No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 95912-01-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-140

Remaining Tasks to be Performed: Clean up, inspect,
powder coat. ✓gc ✓gc ✓gc

Signature: [Signature]

Date: Aug 18 / 2017 Lic. No. / SCA AD 73-04 05

In Process



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AMF 73-04

Nomenclature: HARDWARE No. of pieces: _____

Manufacturer: AERO DESIGN LTD

Part No.: MULTIPLE Serial/Batch No.: 95501-03

TTSN: U/K TSO: N/A Rem.: N/A

Work Order No.: U/K

Remaining Tasks to be Performed: SEE REMARKS

Signature: [Signature]

Date: 18 OCT 2017 Lic. No. / SCA ADD2

Serviceable



Aero Design Ltd.

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AMF 73-04

Serviceable

Remarks

HANDLE, BRACKETS, LID PROP, HARDWARE
(REMOVED) SERVICEABLE FROM BASKET S/N 95911-03



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

MS20001P4-9600

Aircraft:

All

Description:

Hinge

Model: All

Supplier:

GKN Aerospace Bandy Machining

Color:

N/A

WO#:

N/A

PO# 17017

Approved for test use
Adas Reh 26 Oct 2017

Aero Design Ltd.
 AMF 73-04
 95950 (-01RH, -02LH)

Complete Product Assembly Instructions - Bell 429 Cargo Basket

Work Order Number: 2017-174

This sheet is designed to assist in the fabrication of Aero Design products in accordance with the company Manufacturing Policy Manual, the Canadian Aviation Regulations and other applicable technical documentation.

The reference column of the following table is for reference unless a specific instruction is called out.

Install placard on basket body

Parts:

Quantity	Part Number	Description	Material	PO/WO
1	95951-01-XX	Basket Body Assembly	N/A	2017-140
.1	95927-01-XX	Placard	0.050 Sheet, 6061-T6 Aluminum	2015-03
..4	CR3213-4-02	Cherry Rivet	aluminum	17070

Procedure:

Step	Description	Reference	Initial on SOA
1	Align placard on bracket on basket body	dwg 95950	<i>cmb</i> 73-04 01
2	Drill #30 through placard and bracket, using holes in placard.	N/A	<i>CB</i> 73-04 01
3	Remove placard and de-burr holes in placard and on bracket.	N/A	<i>CB</i> 73-04 01

More refs
hardware

Full
review
required
OK

Order

4	Locate placard on bracket, and cleco in place.	dwg 95950	CB 73-01 AD 01
5	Rivet placard with four CR3213-4-02 CherryMax rivets.	N/A	CB 73-01 AD 01

Install lid bumpers

Parts:

Quantity	Part Number	Description	Material	PO/WO
1	95912-01-XX	Basket Lid Assembly	N/A	2017-140
.4	49205-14	Bumper	Argus Industries Bumper	See RDS
.A/R	--	Sealant	Commercial Silicone RTV sealant	N/A

Procedure:

Step	Description	Reference	Initial or SCA
1	Il, 4 places.	dwg 95950	CB 73-01 AD 01
2	licone sealant.	N/A	CB 73-01 AD 01
3	4 places per lid.	N/A	CB 73-01 AD 01

Cut checker plate

Parts:

Quantity	Part Number	Description	Material	PO/WO
1	95917-XX	Lid Checker Plate	3003 Aluminum Tread Plate, 0.063"	17081

Procedure:

Note: Use gloves when touching surface of checker plate to prevent smud

*This is shown
on the
drawing?*

Step	Description	Reference	Initials/SCA
1	Place masking tape on ribs of lid to protect it from the checker plate.		AD 73-01 01
2	Pull checker plate from stock and place on lid so that one end lines up with the top of the radius of the edge of the lid.	dwg 95950	AD 73-01 01
3	Mark the points where the checker plate meets the top of the radius of the other edge of the lid.	N/A	AD 73-01 01
4	Shear checker plate to marked length.	N/A	AD 73-01 01
5	De-burr edges of checker plate with scotch-brite wheel on bench grinder.	N/A	AD 73-01 01
6	Place checker plate on lid and mark locations of notches that are required for the handle flanges.	N/A	AD 73-01 01
7	Using nibbler, remove areas marked for notches on the checker plate making sure corners.	N/A	AD 73-01 01
8	File all edges smooth, starting with the tip of the file tucked in under the edge of rolling, downward stroke. File a radius on the outer corners.	N/A	AD 73-01 01
9	Lay checker plate face down on table with lid accurately placed upside down on checker plate attached.	N/A	AD 73-01 01
10	Trace the ribs of the lid onto the underside of the checker plate with a fine tip Sharpener the lid ribs.	N/A	AD 73-01 01
11	Remove the lid and mark and drill #30 holes in the underside of the checker plate <ul style="list-style-type: none"> a. 0.25" from edge of checker plate, centre on cross members (0.38") b. 0.25" from edge of checker plate, middle of each walkway stringer c. 0.25" from edge of checker plate, additional locations at forward end of basket, as per drawing. 	N/A	AD 73-01 01
12	De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.	N/A	AD 73-01 01
13	Set checker plate aside.	N/A	AD 73-01 01

*This is not
shown on
the drawing?*

Drill holes for hinge in basket, lid, and filler sheet

Parts:

Quantity	Part Number	Description	Material	PO/WO
1	95916-03	Filler Sheet	6160 T6 Aluminum	2016-60
1	MS20001P4	Piano Hinge	95"	17017

Procedure:

Step	Description	Reference	Initial or SCA
1	Place filler sheet, hinge and lid on basket, making sure to align all pieces correctly. Clamp front edge of lid and hold filler sheet in place with lead shot and/or clamps.	N/A	CB 73-01 AD
2	Mark and drill #30 holes through sheet and basket along rear edge of sheet in accordance with drawing. Cleco in place with 1/8 clecos.	dwg 95950 & image 1	CB 73-01 AD
3	Accurately locate hinge and clamp to lid rim. Make a mark on right end of hinge for accurate placement	N/A	CB 73-01 AD
4	Remove filler sheet from damage, drill #30 through holes in hinge into lid. Do the ends first and cleco in place with 1/8	dwg 95950 & image 2	CB 73-01 AD
5	Remove hinge and lid. Replace	N/A	CB 73-01 AD
6	Mark the hinge on the	N/A	CB 73-01 AD
7	Place a hinge on the back of the filler sheet. Make accurate placement of the hinge.	image 3	CB 73-01 AD
8	Remove clecos from hinge and remove lid.		73-01 01 AD
9	Confirm accurate placement of the hinge and clamp in place.		73-01 01

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Image 1

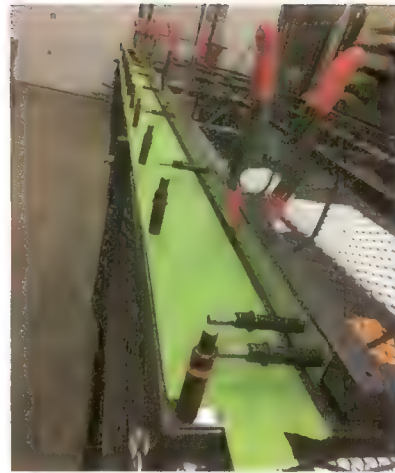


Image 2



Image 3



Image 4

10	Drill #30 through holes in hinge into sheet and basket tube. Cleco in place with 1/8 clecos.	N/A	CB	AD 73-01 01
11	Drill holes up to #21 through hinge, sheet, and tube. Replace 1/8 clecos with 5/32 clecos.	N/A	CB	AD 73-01
12	Remove all clecos and deburr sheet, hinge, lid, and basket tubes	N/A	CB	AD 73-01

Attach checker plate to lid

Parts:

Quantity	Part Number	Description	Material	PO/WO
A/R	CR3213-4-02	Cherry Rivet	aluminum	17070
A/R	N/A	Sealant	Pro-Seal Sealant	N/A

using acceptable
means

Procedure:

Note: Use gloves v

er plate to prevent smudges or marks on the top surface.



Step		Reference	Initial or SCA
1	Carefully place checker plate on lid top. Use lead shot to hold in place.	N/A	73-01 PO1
2	Drill #30 holes into lid through existing holes in checker plate. Cleco in place with 1/8 clecos.	dwg 95950	73-01 PO1
3	Remove checker plate, masking tape, and deburr holes in lid.	N/A	73-01 PO1
4	Apply bead of Pro-Seal sealant along all tubes on lid top.	N/A	73-01 PO1
5	Carefully and accurately place checker plate on lid top. Cleco in place with 1/8 clecos all corners and every other hole.	N/A	73-01 PO1
6	Attach checker plate to lid with CR3213-4-02 rivets.	dwg 95950	73-01 PO1

Attach filler sheet and hinge to body and lid

Parts:

Quantity	Part Number	Description	Material	PO/WO
.. A/R	N/A	Sealant	Pro-Seal Sealant	N/A
.. A/R	N/A	Sealant	Commercial Silicone RTV sealant	N/A
.. 4	CR3523-5-03	Cherry Rivet	monel	14084
.. A/R	CR3213-5-03	Cherry Rivet	aluminum	17039
.. 4	CR3523-5-02	Cherry Rivet	monel	16063 *cms
.. A/R	CR3213-5-02	Cherry Rivet	aluminum	17070

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.. A/R	CR3213-4-02	Cherry Rivet	aluminum	17070
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Procedure:

Step	Description	Reference	Initials or SCA
1	Apply bead of Pro-Seal sealant along all tubes that will be under filler sheet.	N/A	AD 73-01 01
2	Place filler sheet on the basket. Attach with 1/8 clecos along rear edge.	dwg 95950	AD 73-01 01
3	Place hinge on sheet and attach with 5/32 clecos at both ends and every other hole.	dwg 95950	AD 73-01 01
4	Attach sheet and hinge/sheet combination to body with CherryMax rivets. a. CR3523-5-03 monel rivets – last 2 rivets in each end of hinge b. CR3213-5-03 aluminum rivets – all other locations on hinge c. CR3213-4-02 aluminum rivets - all other locations on sheet	N/A	AD 73-01 01
5	Place lid on basket and cleco hinge to lid with 5/32 clecos, both ends and every other hole.	N/A	AD 73-01 01

Note: Protect filler sheet against damage when using the riveting gun.

6	Attach hinge to lid with CherryMax rivets - apply a small amount of RTV silicone to the head of each rivet. a. CR3523-5-02 monel rivets – last 2 rivets in each end b. CR3213-5-02 aluminum rivets – all other locations	N/A	AD 73-01 01
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Install forward sheet to body

Parts:

Quantity	Part Number	Description	Material	PO/WO
.. 1	95965-01	Forward Sheet	6061-T6 Aluminum	2016-60
.. A/R		Sealant	Pro-Seal Sealant	N/A

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.. A/R	CR3213-4-02	Cherry Rivet	aluminum	17070
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Procedure:

Step	Description	Reference	Initials or SCA
1	Clamp forward sheet to basket, starting with the top edge and working your way from top to bottom. Take special care at the corners.	N/A	73-01 AD
2	Mark and drill #30 holes in forward sheet in accordance with drawing, working from top to bottom. Cleco in place with 1/8 clecos.	dwg 95950	73-01 AD
3	Remove sheet and deburr sheet and tube.	N/A	73-01 AD
4	Apply bead of Pro-Seal sealant along all tubes under sheet.	N/A	73-01 AD
5	Locate sheet on basket, cleco in place.	N/A	73-01 AD
6	Rivet sheet with CR3213-4-02 CherryMax rivets.	N/A	73-01 AD
7	Rotate basket on its side to access edge under top rim of basket.	N/A	73-01 AD
8	Mark and drill #30 holes in forward sheet and underside of basket rim in accordance with drawing. Use the angle drill with the #30 bit (threaded end), which is on the peg board labeled "429 #30 Angle Drill".	dwg 95950	73-01 AD
9	Using low profile manual riveter, rivet sheet with CR3213-4-02 CherryMax rivets.	N/A	73-01 AD

Install Attachment Fittings

Parts:

Quantity	Part Number	Description	Material	PO/WO
.. 4	96710-01	Fitting	Alternate: Ancra 40088-14	See PDS
.. 8	NAS1149F0663P	Washer	N/A	See PDS

.. A/R	N/A	anti-seize compound	N/A	N/A
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Procedure:

Step	Description	Reference	Initial or SCA
1	Carefully remove excess powder coat from around attachment lug threads using a countersink.	N/A	CB 73-01 PO1
2	Run 3/8-24 tap into attachment lugs to clear threads.	N/A	CB 73-01 PO1
3	Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)	N/A	CB 73-01 PO1
4	Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.	N/A	CB 73-01 PO1
5	Torque to 160-190 in-lbs (13.3-15.8 ft-lbs).	N/A	CB 73-01 01

Install handle brackets

Parts:

Quantity	Part Number	Description	Material	PO/WO CMB
1	84255-01	Handle Installation	N/A	N/A
.. 2	84267-01	Bracket	Delrin, 1/2" Sheet	2017-50
.. 4	AN3-11A	Bolt	N/A	See PDS
.. 8	NAS1149F0363P	Washer	N/A	See PDS
.. 4	MS21044N3	Nut	N/A	See PDS

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Procedure:

Step	Description	Reference	Initial or SCA
1	Set 84267-01 handle bracket on provisions in hoops, 2 places. It may be necessary to clear the powder coating out of the holes with an angle drill and a #9 bit.	dwg 84255	73-04 AB
2	Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.	dwg 84255	73-04 AD
3	Torque AN3 bolts to 20-25 in-lbs.	N/A	73-04 01

Install handle

Parts:

Quantity	Part Number	Description	Material	PO/WO
.. 1	84261-01	Handle Assembly	N/A	2016-60
.. 2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	See PDS
.. 2	36275-01	Bushing	Brass, 5/16" Dia	See PDS
.. 2	AN3-12A	Bolt	N/A	See PDS
.. 4	NAS1149F0363P	Washer	N/A	See PDS
.. 2	MS21044N3	Nut	N/A	See PDS
.. A/R	N/A	Mobil Grease 28 or equivalent	N/A	N/A

Procedure:

Step	Description	Reference	Initial or SCA
1	Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.	N/A	AD 73-01 AD01
2	Grease two 36275-01 bushings with Mobil Grease 28 or equivalent. Insert into bushings of handle assembly.	N/A	73-01 AD01
3	Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.	dwg 85255	73-01 AD
4	On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and	N/A	73-01 AD01
5	At first end, remove bolt and repeat step 4	N/A	73-01 AD
6	Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.	N/A	73-01 AD
7	Torque AN3 bolts to 20-25 in-lbs.	N/A	AD 73-01 01

Check handle**Procedure:**

Step	Description	Reference	Initial or SCA
1	Operate handle to ensure handle does not bind and springs hold handle in.	N/A	AD 73-01 AD01
2	Snap handle into brackets to ensure handle locks.	N/A	73-01 AD 01

Install Lid Brace

Parts:

Quantity	Part Number	Description	Material	PO/WO
..1	36280-01	Brace Assembly	N/A	2017-170
..1	AN3-15A	Bolt	N/A	See PDS
..1	AN3-17A	Bolt	N/A	See PDS
..2	AN970-3	Washer	N/A	See PDS
..3	NAS1149F0363P	Washer	N/A	See PDS
..2	MS21044N3	Nut	N/A	See PDS

Procedure:

Step	Description	Reference	Initial or SCA
1	Locate 36280-01 lid brace on bushing on basket body. Ensure brace is on forward end of basket as it will be installed on the helicopter.	N/A	AD 73-04 01
2	On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid brace, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.	dwg 84240	AD 73-04 01
3	On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.	dwg 84240	AD 73-04 01
4	Ensure brace is seated on lip of bushings before tightening nuts. This may require the removal of powder coating with a knife or sharp-edged file.	N/A	AD 73-04
5	Torque AN3 bolts to 20-25 in-lbs.	N/A	AD 73-04 01

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Notes/Cautions/
warnings
should be
separate ↓

Procedure:

Step	Description	Reference	Initial or SCA
1	Note: This should be completed by someone who did not assemble the basket. Dual inspection.	N/A	
2	Check for general condition and correct assembly: a. Bolts are tight b. Rivets are installed correctly c. Handle operates correctly d. Lid brace operates correctly	N/A	
3	Check that PO/WO numbers have been recorded.	N/A	